

Date: Friday, 8/3/2007 9:23:58 AM
User: Jean-Luc Menard

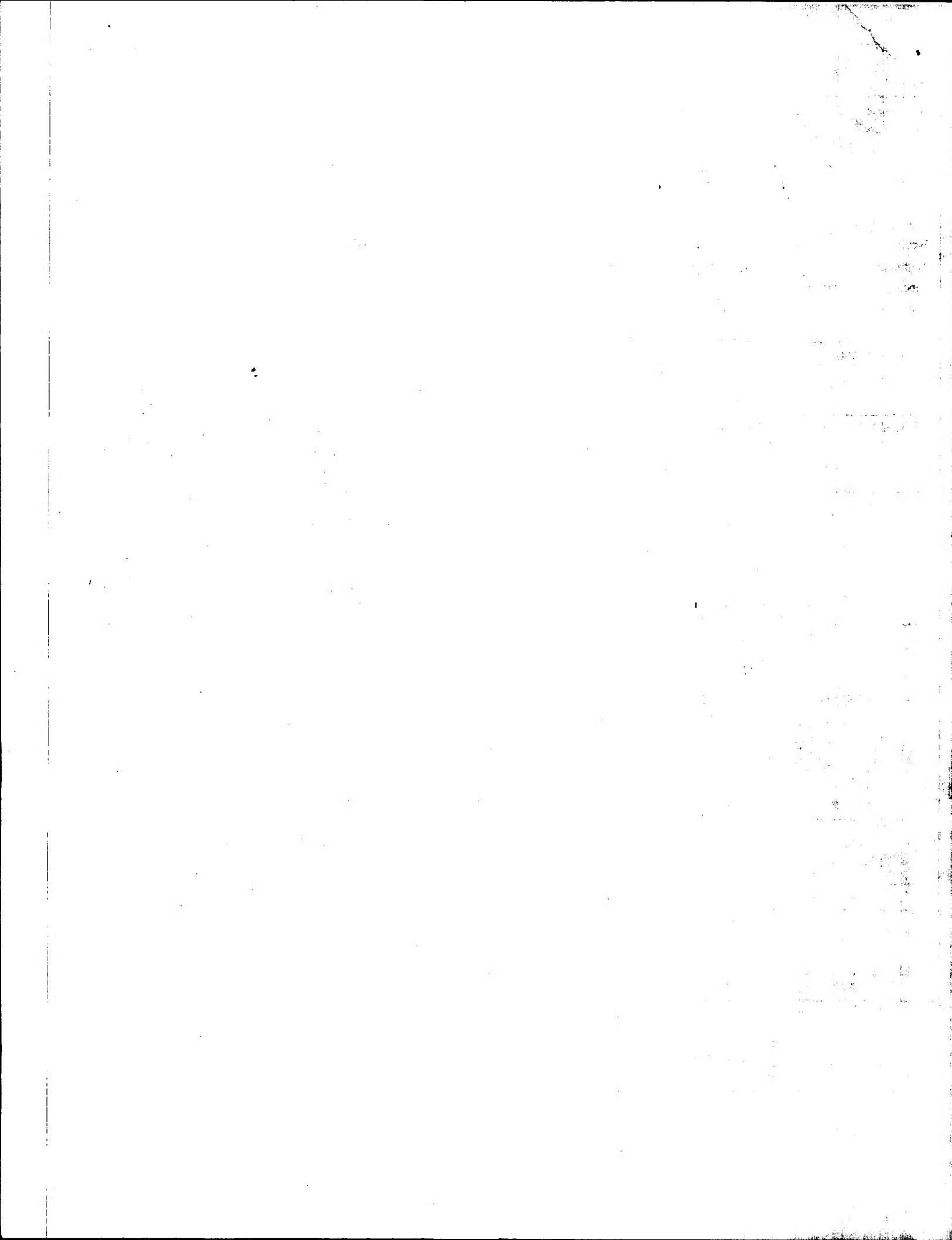
Process Sheet

Next

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE	
Job Number	: 33828				
Estimate Number	: 11177				
P.O. Number	: N/A		Part Number	: D2281	
This Issue	: 8/3/2007		S.O. No.	: N/A	
Prsht Rev.	: NC		Drawing Number	: D2281 REV G	
First Issue	: 8/3/2007		Type	: SMALL /MED FAB	
Previous Run	: 33414		Project Number	: N/A	
Written By	<u>JLM 07-08-B.</u>		Drawing Revision	: G	
Checked & Approved By			Material	: N/A	
Comment			Due Date	: 8/10/2007	
			Qty:	60	Um: Each
Est Rev:A Removed from 9 Digit 05-12-02 JLM					
Est: rev B 06.07.17 waterjet EC					

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
		
Comment: Qty.: 0.1313 sf(s)/Unit Total : 7.8750 sf(s) 304SS .080 batch: M105112 1B 07-08-S		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> 1B 07-08-05 Prog Rev: <u>G</u>		
2-Deburr if necessary 0.11 07.08.07		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>1B 07-08-05</u>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK En 07/08/07		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: Deburr 0.11 07.08.07 63		



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 33828

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 07/08/07 63

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/08 63

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: JS 6

07/08/08 63

9.0 QC21 FINAL INSPECTION/W/O RELEASE



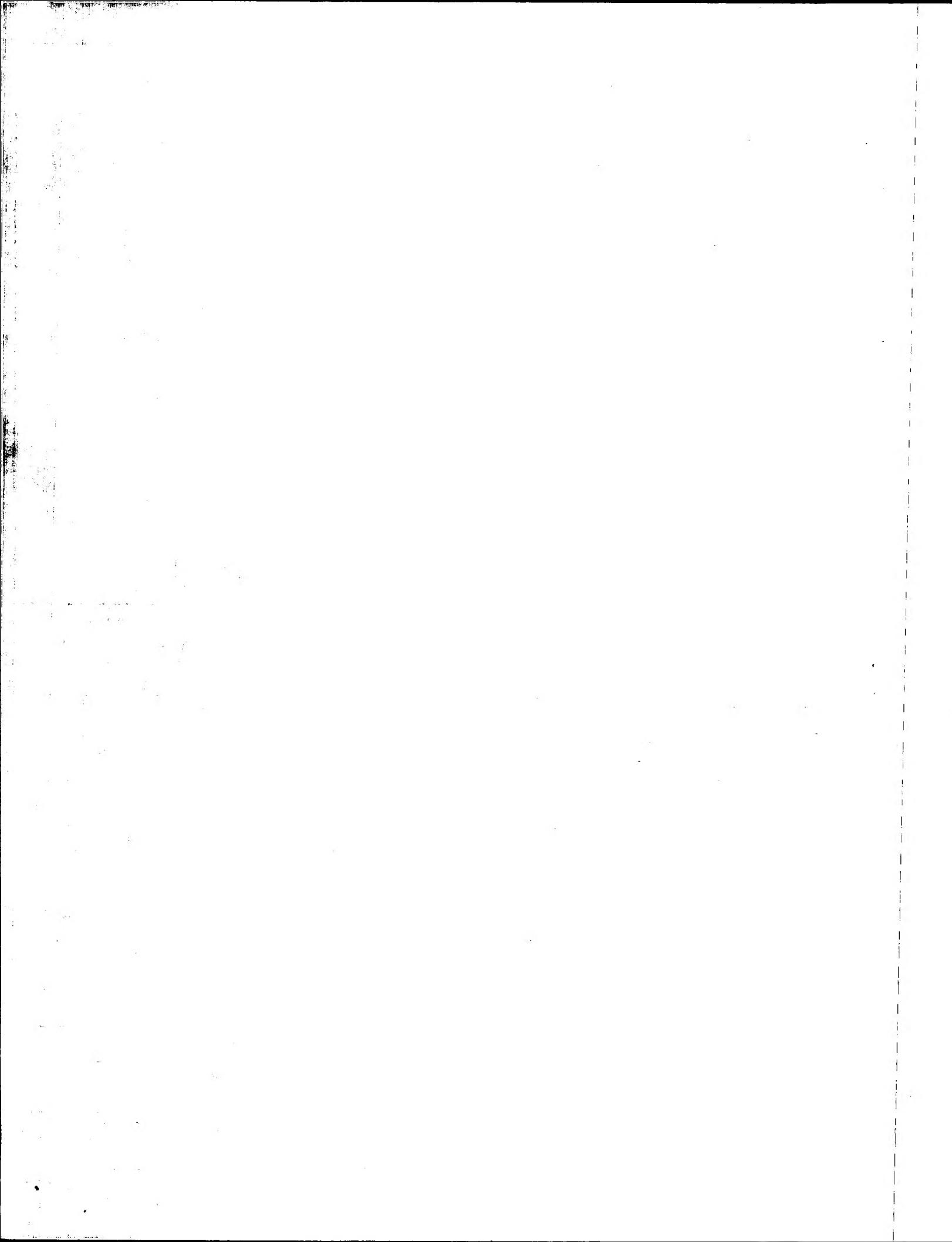
Comment: FINAL INSPECTION/W/O RELEASE

07/08/09

Job Completion



07/08/09



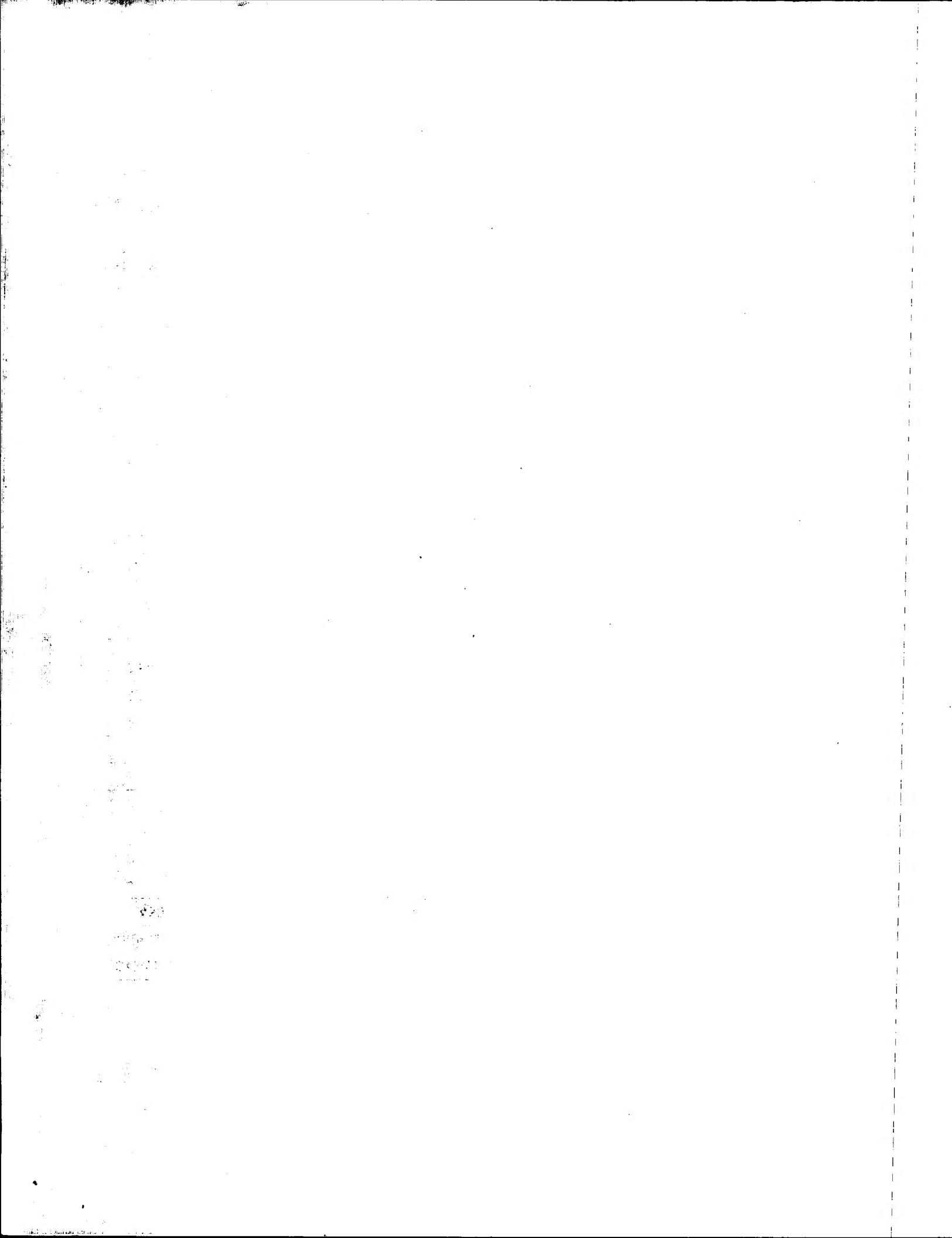
DART AEROSPACE LTD	Work Order:	
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>SP</u>	Prototype Approval:	N/A
Date:	07-08-05	Date:	07/08/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	JL

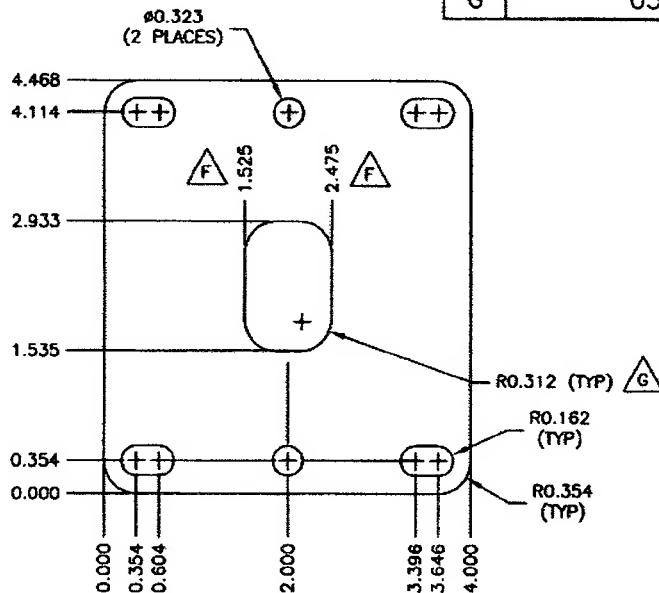




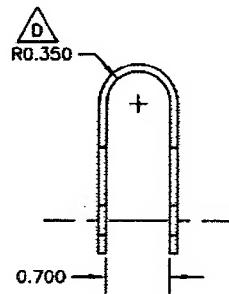
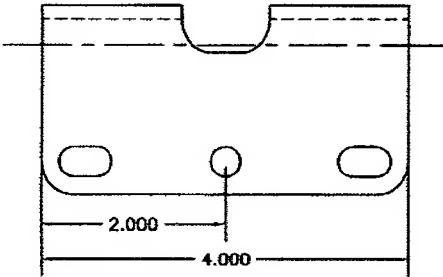
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>(P)</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11



FLAT LAYOUT



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
 - 2) FINISH: NONE
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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